

Split
Work Order ID 145525-2

145525

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Friday, May 06, 2016 9:07:57 AM

Item ID: D3690-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Glareshield Assembly
 Start Date: 4/26/2016 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 5/5/2016 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: Em Date: 16/05/09 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3690	Rev C

100	Pick Kit	0.00
-----	----------	------

100						<u>1</u>	<u>FF</u>	<u>JUL 12 2016</u>
Packaging	Memo	0.00						
Packaging								

110	Small Fab	0.00
-----	-----------	------

110						<u>1</u>	<u>FF</u>	<u>JUL 12 2016</u>
Small Fab	Memo	5.34						
Small Fab	1- transfer drill D3697-041 and D3698-1 in D3690-1 and assemble as per dwg D3690 ***USE DT9809*** 2- scribe batch # and part # as per dwg							

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Item ID: D3690-041

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Stop ***NS2***

Item Name: Glareshield Assembly

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2

Cust Item ID:

Required Date: 5/5/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00				1			DAS 38 9-89
120 QC Quality Control	Memo	0.04							JUL 12 2016
130	SprayPaint	0.00				1			
130 SprayPaint Spray Painting	Memo 1- Mask hatched areas (6 pls) on inside of the part prior to painting as per dwg 2-Paint D3690-041 assy flat black using Basf Glasurit 22 Line code SFA39.50 per Dart QSI 005 4.2 BATCH # 133900	2.50							2-11-16
140	QC14- Inspect Spray Paint	0.00				1			DAS 38 9-89
140 QC Quality Control	Memo	0.02							NOV 03 2016

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2

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: St

0.00

150

Packaging

Memo

0.02

Packaging

/ NOV 03 2016

DAS
6
9-89

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.20

Quality Control

16/11/8 J

NOV 03 2016

DAS
21
9-89

Picklist Print

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Work Order ID: 145525

145525

Parent Item: D3690-041

D3690-041

Parent Item Name: Glareshield Assembly

Start Date: 4/26/2016

Required Date: 5/5/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-04-29 new issue DD verified by:ec
IPP Rev:B 08-07-14 revB as per dwg DD verified by:ec
IPP Rev:C 08-09-08 added painting DD verified by:EC
IPP Rev:D 08-10-07 revC as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
CR3213-4-03		Purchased	No				Each	190.0000		70			
CR3213-4-03									**			JUL 12 2016	
rivet													

Location	Loc Qty	Loc Code
GA	184	
m129913	84	
m131803	100	
ST319	6	
m127831	6	

D3690-1 Manufactured No

Each 0.0000 DAS 30 2
B 145665 ****** **(2)** **JUN 14 2016**

D3690-1

Glareshield

D3697-041 Manufactured No

Each 0.0000 DAS 30 2
B 147213 ****** **(2)** **JUN 14 2016**

D3697-041

Tube Assembly

D3698-1 Manufactured No

Each 8.0000 DAS 30 2
B 145708 ****** **(2)** **JUN 14 2016**

D3698-1

Support Angle

Location	Loc Qty	Loc Code
ST260B	8	
111034	6	
82743	2	

DAS 30 2
2 **JUN 14 2016**

Picklist Print

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Parent Item: D3690-041

D3690-041

Parent Item Name: Glareshield Assembly

Start Date: 4/26/2016

Required Date: 5/5/2016

Start Qty: 2.00

Required Qty: 2.00

MS20426AD3-5

MS20426AD3-5

Rivet

^{DAS}
4 30
Purchased
8-89

No

→ M131697 (2)

Each

4,719.000

4

**

FF

JUL 12 2016

Location

Loc Qty

Loc Code

GA

4144

4533

4144

ST312

575

4444

575

NAS1149DN332J

NAS1149DN332J

Washer

Purchased

No

Each

492.0000

4

**

FF

JUL 12 2016

Location

Loc Qty

Loc Code

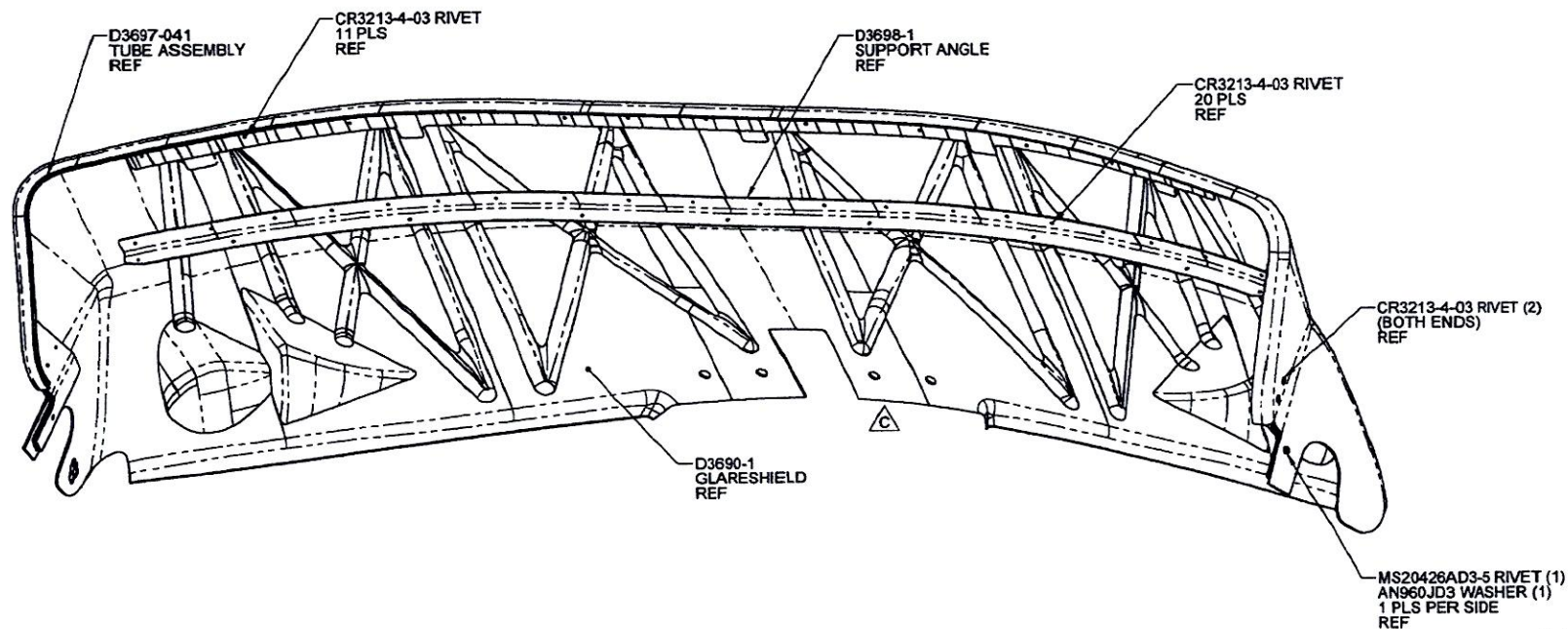
ST265

492

m127831

492

2



PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3690-041	GLARESHIELD ASSEMBLY
1	D3690-1	GLARESHIELD
1	D3697-041	TUBE ASSEMBLY
1	D3698-1	SUPPORT ANGLE
2	AN960JD3	WASHER (OR NAS1149DN332J)
2	MS20426AD3-5	RIVET
35	CR3213-4-03	RIVET

D3690-041 GLARESHIELD ASSEMBLY

C	SHEET 1 PL MS20426AD3-5 RIVET WAS MS20426AD3-4, CR3213-4-03 RIVET WAS MS20470AD3-4, WASHER QTY WAS 6 (VIEWS UPDATED ACCORDINGLY). RIVETS ON SHEET 1 CHANGED TO REF QTY. RIVETS ON SHEET 2 CHANGED TO "HARD" CALLOUTS. SHADING REMOVED FROM ALL VIEWS FOR CLARITY.	AJS	08.09.02
B	ADD FINISH COAT & 1.0 TYP. SHEET 2 ZONES A, B & C.5; ADD MIN THICKNESS. SHEET 3 ZONE A, B	RF	08.06.24
A	NEW ISSUE	RF	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3690	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GLARESHIELD ASSEMBLY	NTS
DATE	08.09.02	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
28-09-16-18

w/o 145525

28m 16/03/09

TRANSFER DRILL $\varnothing 0.128$
FROM D3698-1 TO D3690-1
INSTALL
CR3213-4-03 RIVET, 20 PL
RIVET HEAD ON GLARESHIELD
OUTSIDE SURFACE

D3690-1
GLARESHIELD
REF

TRANSFER DRILL $\varnothing 0.098$
FROM D3697-041 TO D3690-1
INSTALL
MS20426AD3-5 RIVET
AN960JD3 WASHER (ON GLARESHIELD
OUTSIDE SURFACE)
1 PER SIDE

TRANSFER DRILL $\varnothing 0.128$
FROM D3697-041 TO D3690-1
INSTALL
CR3213-4-03 RIVET 2
BOTH ENDS

0.14
REF

SECTION A-A

EQUAL DIMENSION
AT BOTH ENDS

TRANSFER DRILL $\varnothing 0.128$
FROM D3697-041 TO D3690-1
INSTALL
CR3213-4-03 RIVET, 11PL
RIVET HEAD ON GLARESHIELD
OUTSIDE SURFACE

TRANSFER DRILL $\varnothing 0.144$
AT THIS LOCATION
FROM D3697-041 TO D3690-1
(NO HARDWARE INSTALLED)

D3698-1
SUPPORT ANGLE
REF

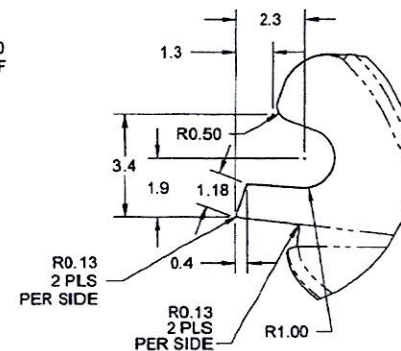
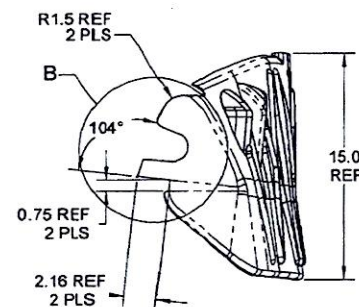
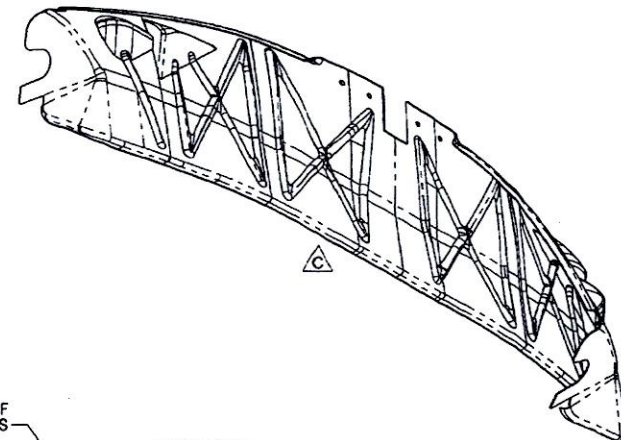
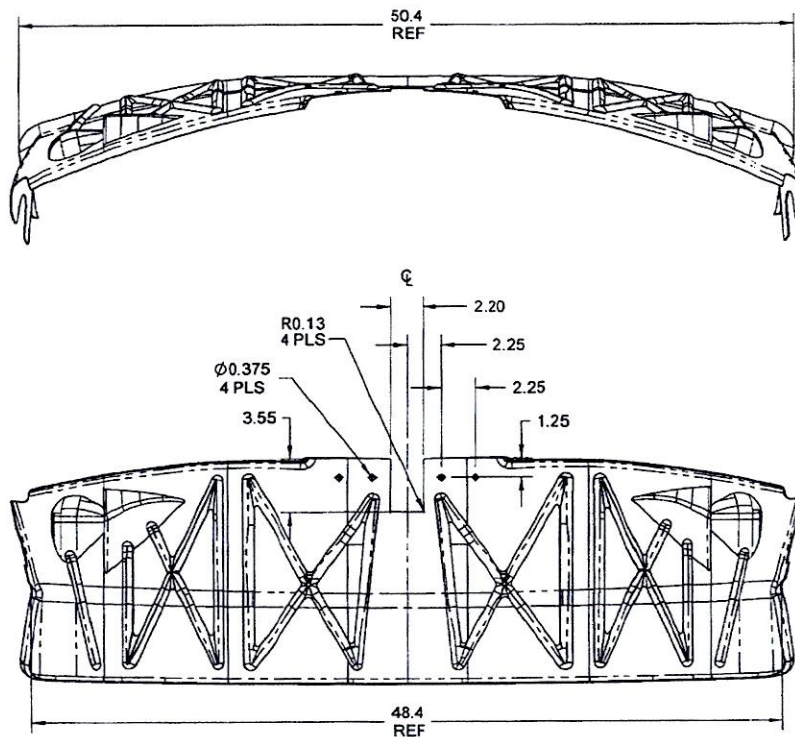
D3690-041 GLARESHIELD ASSEMBLY

NOTES:

- 1) CENTER D3697-041 AND D3698-1 ON TO D3690-1
- 2) FINISH: PAINT D3690-041 ASSY FLAT BLACK USING BASF GLASURIT 22 LINE CODE SFA39.50 PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFICATION: ETCH WITH DART P/N D3690-041 & B/N ON INSIDE OF PART
- 5) WEIGHT: 2.98 lbs
- 6) MASK HATCHED AREAS (6 PLS) ON INSIDE OF THE PART PRIOR TO PAINTING

RELEASED
08-09-11

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3690	SHEET 2 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	GLARESHIELD ASSEMBLY	NTS
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D3690-1 GLARESHIELD

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED 701 BLACK FLAT LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 2) TOOLING: THERMOFORM PER MOLD DT9010 PER QSI 022
TRIM PER MOLD SCRIBE LINES EXCEPT WHERE NOTED
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 2.5 lbs
- 9) MINIMUM THICKNESS AFTER FORMING IS 0.040

RELEASED
08.09.02

DETAIL B
SCALE 2X
THIS VIEW FOR REFERENCE ONLY

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. C
MFG. APPR.		D3690	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GLARESHIELD ASSEMBLY	NTS
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